August 21, 2009 10:17:39 AM

Item ID:

D3171-1

Α

Item Name: Angle

Required Date: 8/27/09

Start Date:

Revision ID:

8/21/09

Start Qty: 20.00

Req'd Qty: 20.00



Accept

Setup Start



Stop

Reference:

Approvals:

Process Plan:

QC:

Date: 09/88/5/ Tooling:

SPC (Y/N):

Date:

Date:

Cust Item ID:

Customer:

Start Run

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr					26			
D3171	Rev A								
100		0.00		• • • • • • • • • • • • • • • • • • • •		-			

FLOW CNC Waterjet

Waterjet

FLOW WATER JET

Memo

0.00

1-Cut as per Dwg D3171 | Dwg Rev:_

Date:

A LiProg Rev: A 1.12-

Deburr if necessary

QC2- Inspect parts off machine FAI/FAIB

110

0.00

Memo

0.00

H39-8-17

B 9-8-17

Quality Control

120

QC

QC8- Inspect parts - second check

Memo

25/30/10 C C=

Quality Control

0.00

Dart Aeros	pace Ltd
-------------------	----------

W/O:		WORK ORDER CH	WORK ORDER CHANGES							
DATE	STEP PROCEDURE CHANGE By					Approval Chief Eng / Prod Mgr	Approval QC Inspector			

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:			WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
						·					
-											
							,				
								ľ			

NOTE: Date & initial all entries

H:\fFOftMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 51410

August 21, 2009 10:17:39 AM

Item ID:

D3171-1

Revision ID: Α

Item Name: Angle

Start Date:

8/21/09

QC:

Start Qty: 20.00

Required Date: 8/27/09

Req'd Qty: 20.00



Accept



Setup Start



Stop

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

..

Date: Date:

Tooling:

0.00

SPC (Y/N):

Date:

Run

Start Stop

Sequence ID/ **Work Center ID**

130

Small Fab

Small Fab

Operation **Description**

Small Fab

Deburr if necessary

Set Up/ **Run Hours**

Draw Number Draw Rev.

Date:

Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

Memo

mik 09/08/25



140

Brake NC

NC BRAKE

Memo

Brake NC Bend as per Dwg D31711 |Tumble

0.00 SB 09/08/26

150

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

Dart Aero	space	L	td
------------------	-------	---	----

Dail Ac	iuspace	Liu					
W/O:		WORK ORDER (CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	ļ						
L			<u> </u>				
Part No):	PAR #: Fault Category:	NCR: Yes	No DQ	A:	_ Date: _	

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Res	solution:	Disposition:	QA: N/C Closed:	Date:

		WORK ORDER NON-CONFORMANCE (NCR)								
	Description of NC		Corrective Action Section B			Approval	Approval			
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
	,									
				ļ						
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Section C	STEP Description of NC Section A Initial Action Description Sign & Verification Section C Chief Eng			

NOTE: Date & initial all entries

⁺ H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Page 3

August 21, 2009 10:17:39 AM

Item ID:

D3171-1

Accept

Setup Start

Stop



Revision ID: Item Name: **Start Date:**

Angle

Α

8/21/09

Start Qty: 20.00 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Required Date: 8/27/09

Process Plan:

Date:

Tooling:

Date:

Start Run

QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Sequence ID/

Work Center ID

160

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

Memo

0.00

0.00

Draw Number

Draw Rev.

Plan

Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

170

QC21- Final Inspection - Work Order Release

0.00

09/08/31 AS

Quality Control

0.00

Picklist Print

August 21, 2009 10:17:39 AM

Work Order ID: 51410

Parent Item:

D3171-1RevA

Parent Item Name: Angle

Start Date: 8/21/09

Required Date: 8/27/09

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name

Replacement Item ID

Mfg/ Purch

Purchased

Bin Primary Item Location

No

Last Location 100

Route Seq ID Unit of Measure Hand

sf

Qty on Remaining Qty Qty To Pick Issued Date Issued Status

M304S16GA

Comments:

304/316 Sheet .063

Warehouse

Loc Qty

206.3330 0.4337

Location

Main Warehouse

MAT

206.3329737 16.018

106860 111924 112290

33.0549737 157.26 Loc Code

112990

B9-8-17

Dart Aerospace Ltd

W/O:		WORK ORDER C	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE				Approval Chief Eng / Prod Mgr	Approval QC Inspector		
.,									
			1						

Part No:		PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
D.4.T.E.	0===	Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto
		•						

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	51410
Description: ANGLE	Part Number:	D3171-1
Inspection Dwg: \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\	·	Page 1 of 1

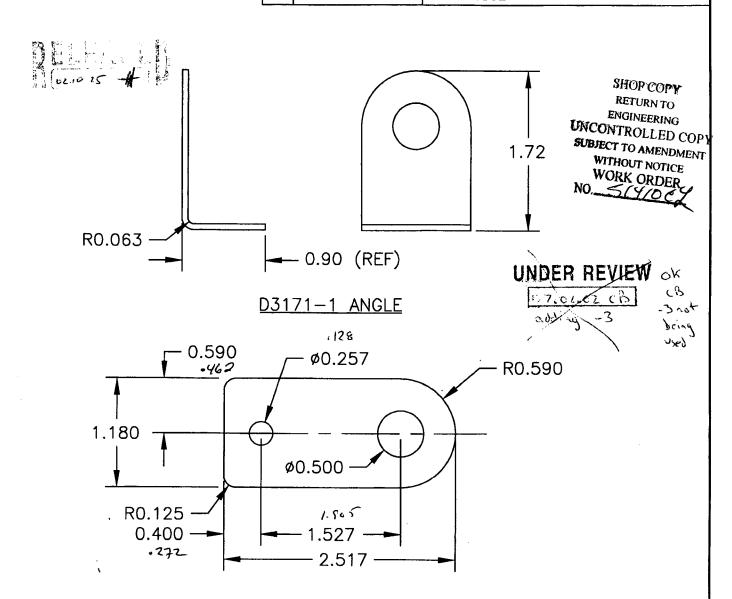
FIRST ARTICLE INSPECTION CHECKLIST							
X First Article Prototype							
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comr	nents
6 , 257	100 000, +	, २८५	٨				
500	1000 - 000, +	, 561	M				
092,	4 .010	590	6				
,400	4 010	,400	>p				
1.180	1/2 :010	1.184	y				<u>-</u>
1.527	4 .010	1.527	*				
2.517	4 .010	5,533	y ∂		·		
.063	4 .010	1059	b		·		
			·				•
·							
					·		
:							
		<u> </u>					
· · · · · · · · · · · · · · · · · · ·	:						
·							
· · · · · · · · · · · · · · · · · · ·			·				
	_						
	·						
Measured by:		udited by:			ototype Approv	al: /	/
Date:	3 AI 9-8-17		2/10/20			te: /9	
		<i>O</i>	1/08/25				\
Rev Date	Change New Issue		· · · · · · · · · · · · · · · · · · ·	·····	Revi	sed by	pproved

Rev	Date	Change		Revised by Approved
Α	• • •	New Issue		KJ/JLM
			•	





DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	D3171	REV. A SHEET 1 OF 1	
DATE		TITLE	SCALE	
02.10.08		ANGLE	1:1	
Α	02 10 08	NEW ISSUE		



D3171-1 ANGLE FLAT PATTERN

- MATERIAL: AISI 304/316 ANNEALED SS SHEET 0.063 THICK PER MIL-S-5019 (REF. DART SPEC. M304S16GA)
- TOLERANCES ARE PÈR DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- BREAK ALL SHARP EDGES 0.005 TO 0.010

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.